

Work Order ID 144949

April 27, 2016 3:18:20 PM

144949Bell order shipping
May 10

Page 1

Item ID: D3204-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Release Pedal Assembly

Stop

NS2

Start Date: 4/28/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: SLTDate: 20160427

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00

100

Large Fab

Large Fab

Memo

0.78

Large Fab

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

1 12-16-5-9

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

① 16-05-090253
9
2-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
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								Lead hand / Supervisor Approval Verification																																																							
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : ☐																																																															

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Page 2

Item ID: D3204-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Release Pedal Assembly
 Start Date: 4/28/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120									
QC	Memo	0.02							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.15							
Hand Finishing									
140	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							DAS 13 9-89
140									
Powdercoat	Memo	0.05							
Powder Coating	***Cover holes for bushing***								
Outsource	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								

135
 140
 Powdercoat
 Outsource
 145
 packaging

Powder Coat
 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3
 M 130746

0.00
 DO 32331
 0.05

① 16-05-09

1 16-5-9

1 MAY 10 2016

Receive + Inspect

14 SP/6-05-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144949

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Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Release Pedal Assembly
Start Date: 4/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/5/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00		DAS 30 9-89					
180									
Packaging	Memo	0.01							
Packaging	LOCATION : GA								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.10							
Quality Control									

MCS MAY 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						
OTHER : ☐								

Picklist Print

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Page 1
1/2

Work Order ID: 144949

144949

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/28/2016

Required Date: 5/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 *D3204-1* Tube		Manufactured	No			100	Each	1.0000	1	1			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002			1					
					109095			1					
D3204-11 *D3204-11* Plate		Manufactured	No			100	Each	10.0000	1	1			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002			10					
					141528			10					
D3204-13 *D3204-13* Gusset		Manufactured	No			100	Each	35.0000	2	2			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002			35					
					136371			35					
D3204-3 *D3204-3* Arm		Manufactured	No			100	Each	0.0000	1	1			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002			35					
					136371			35					

144602x1

Picklist Print

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Work Order ID: 144949

144949

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/28/2016

Required Date: 5/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3204-5 Manufactured No 100 Each 9.0000 1 1

D3204-5

Arm

**

EL 16-5-9

Location

Loc Qty

Loc Code

WA002

9

132473

1

142462

8

D3204-9 Manufactured No 100 Each 10.0000 1 1

D3204-9

Pedal

**

EL 16-5-9

Location

Loc Qty

Loc Code

WA002

10

142457

10

D3204-7 Manufactured No 160 Each 13.0000 2 2

D3204-7

Bushing

**

MAY 12 2016

Location

Loc Qty

Loc Code

GA

13

136548

13

DAS

30

9-89

2

April 27, 2016 3:18:24 PM

Shop Packet Print

Page 2

DART

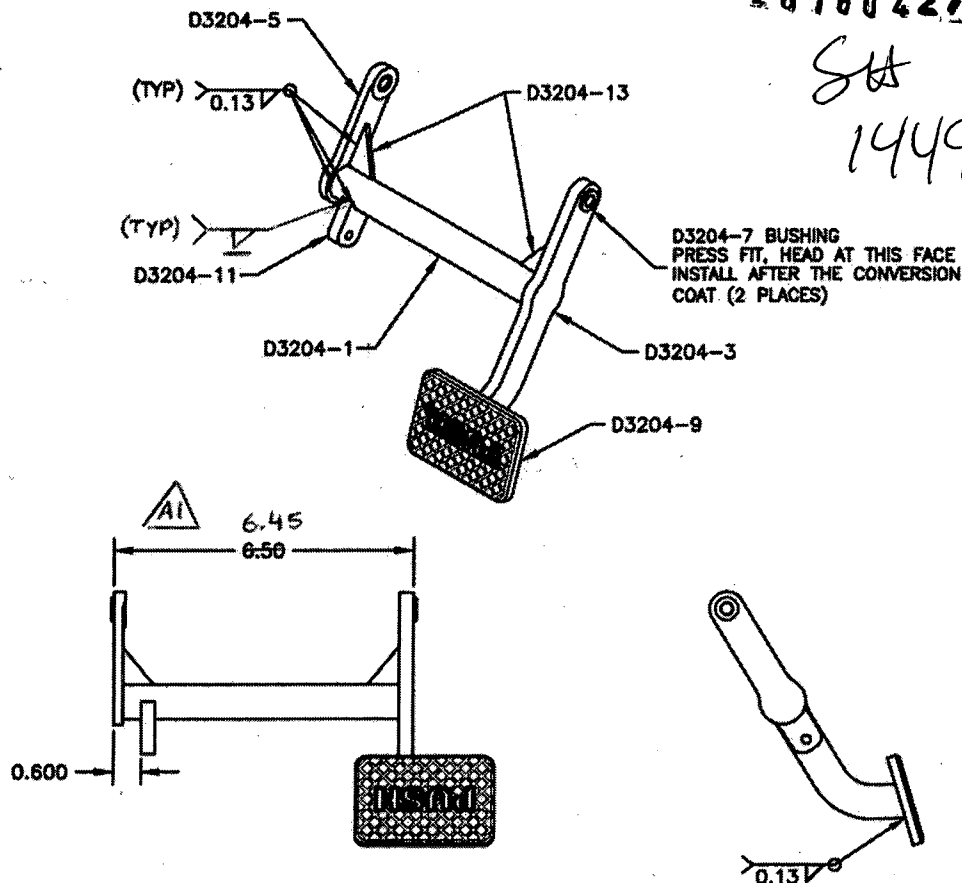
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
#4.04.30

20160427

SH

144949



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

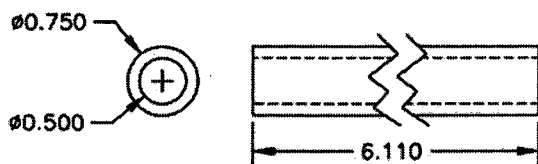
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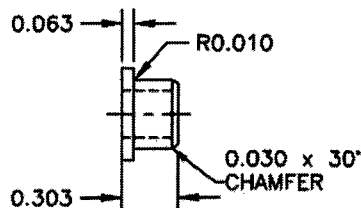


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

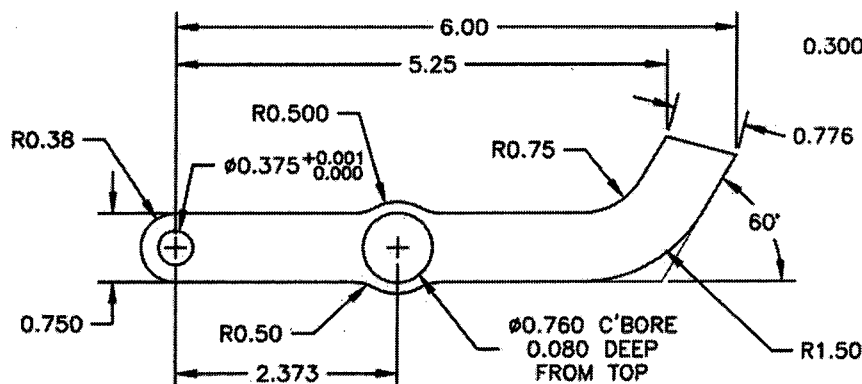
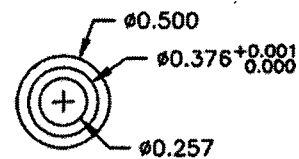
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04.04.05 [Signature]



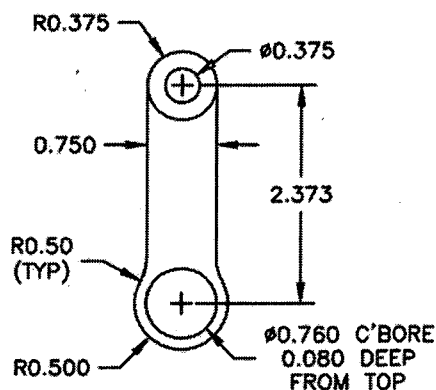
2 D3204-1 TUBE
SCALE 1:2



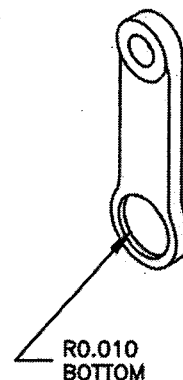
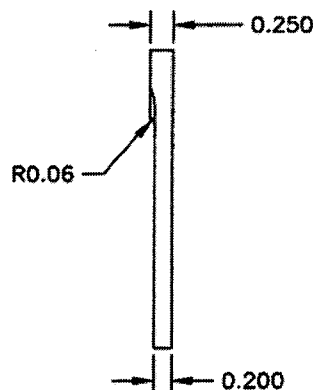
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



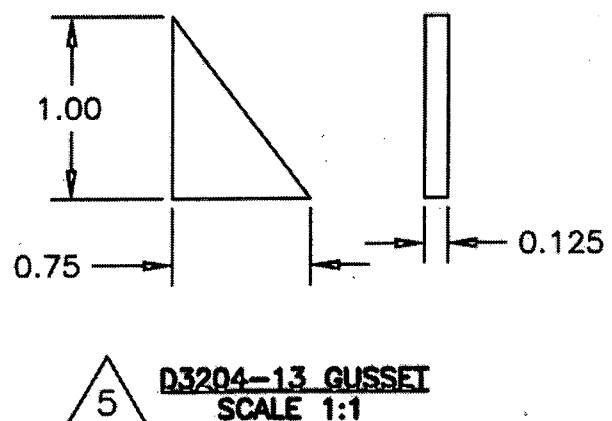
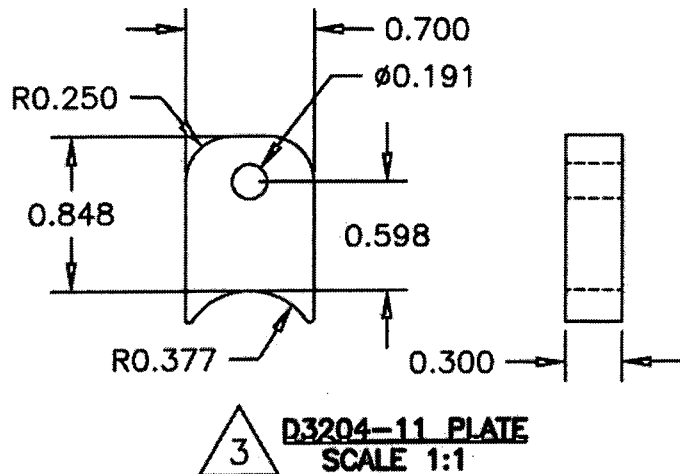
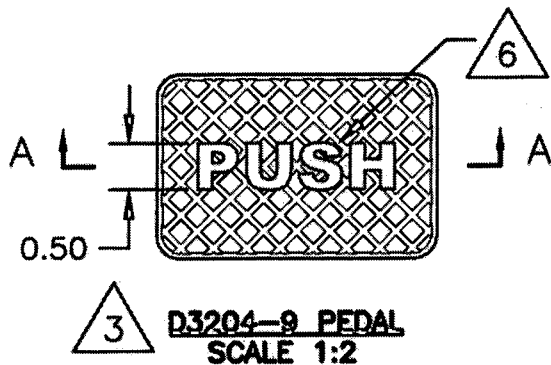
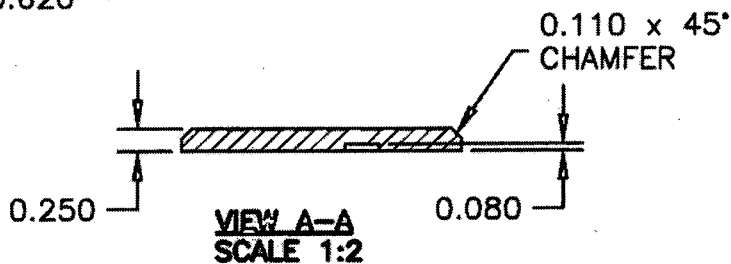
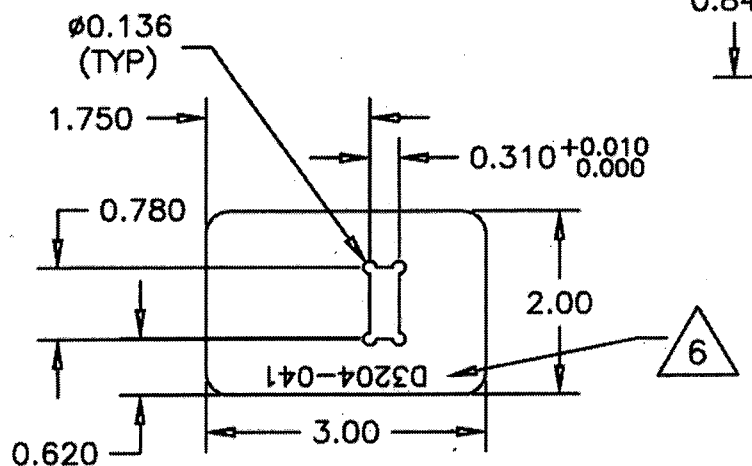
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.30



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32331**

Purchase Order Date 5/10/2016

PO Print Date 5/11/2016

Page Number 3 of 3

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

7	144917	D3572-041 GUIDE	5/12/2016 Yes 5/12/2016	2.00	\$14.00	\$28.00
Powder coat per QSI005						
						Line Total: \$28.00
8	144831	D3196-1 BAR	5/12/2016 Yes 5/12/2016	6.00	\$18.00	\$108.00
Powder coat per QSI005						
						Line Total: \$108.00
9	144949	D3204-041 RELEASE PEDAL	5/12/2016 Yes 5/12/2016	1.00	\$20.00	\$20.00
Powder coat per QSI005						
						Line Total: \$20.00
						PO Total: \$605.50

PO Instructions: PROCUREMENT QUALITY CLAUSES
A000 CLAUSES NOT REQUIRED

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 5/11/2016

Generic Quote Calculator - quoted by: Roger L

Line	Part Number	Qty	Requirement 1	Unit Cost	Req 2	Unit Cost	Req 3
1	142768	14	powder coated	\$5.25		\$0.00	
2	142663	14	powder coated	\$9.00		\$0.00	
3	144623	12	powder coated	\$9.00		\$0.00	
4	144747	8	powder coated	\$9.00		\$0.00	
5	144749	10	powder coated	\$5.00		\$0.00	
6	143417	1	powder coated	\$20.00		\$0.00	
7	144917	2	powder coated	\$14.00		\$0.00	
8	144831	6	powder coated	\$18.00		\$0.00	
9	144949	1	powder coated	\$20.00		\$0.00	
10	Adminastration fee			\$125.00		\$0.00	
11						\$0.00	
12						\$0.00	
13						\$0.00	
14						\$0.00	
15				\$0.00		\$0.00	
16				\$0.00		\$0.00	
17				\$0.00		\$0.00	
18				\$0.00		\$0.00	
Repeat Job		YES	NO	Black Ano \$125	Color Ano \$150.00	Passivate	
Lot Charges		Paint \$185	Clear Ano \$125	Hard Ano \$175	Chem Film		
COMMENT							
PO32331							
Pricing is based on lot charges when possible							
Anodize Pricing is based on how many parts can be processed per hour - when exceeding lot ch							
Painting Pricing is based on how many parts can be processed per hour - when exceeding lot ch							

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Unit Cost	TOTAL COST
\$0.00	\$73.50
\$0.00	\$126.00
\$0.00	\$108.00
\$0.00	\$72.00
\$0.00	\$50.00
\$0.00	\$20.00
\$0.00	\$28.00
\$0.00	\$108.00
\$0.00	\$20.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$605.50
\$115.00	
\$115.00	
arges	
arges	

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